



WORK ORDER 2008-06

Date opened: 6 February 2008

Project: Attachment Provisions  
Type: Eurocopter AS350/355 SeriesBatch Quantity: 2 Sets of 4 Clamp Assemblies (78620-01)  
1 Pair Low Beams (78630-01)  
1 Pair High Beams (78630-02)Approval: Pending 5/10/08-16  
Drawing List: DCL786-3

Fabrication and Assembly Drawing(s)	Description
78620, Rev. 0	Clamp Ass'y
78630, Rev. 0	Low Beam
78631, Rev. 0	High Beam

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: \_\_\_\_\_

  
Inspector Signature:  
Date:~~SEE WO 2008-05 FOR RELEASE TAGS~~

Drawing: 78620 Revision 0  
Assembly: 78620-01 Clamp Ass'y

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 sets	78620-01	Clamp Assembly			
1	78620-02	Attachment Clamp	6061-T6 Aluminum, 3.5 x 1 bar	8014	
1	78620-03	Clamp	6061-T6 Aluminum, 3.5 x 1 bar	8014	
1	77620-04	Barrel Nut	304 Stainless Steel, 0.5 Dia Rod		
1	77620-05	Curved Washer	6061-T6 Aluminum, 0.5 Dia Rod		
3	3591-4CN375	1/4-28 Self Locking Helicoil		8016	
1	AN4-7A	Bolt			
1	AN4-20A	Bolt			
2	AN960-416	Washer			

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 78620			<i>JK.</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 78630 Revision 0  
Assembly: 78630-01 Low Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Pair	78630-01	Low Beam Assembly			
1	78630-02	Tube	304 Stainless Steel, 1x2x0.125 tube		
1	78630-03	Cap	321 Stainless Steel, 0.025 Sheet		
2	78630-04	Bushing	304 Stainless Steel, 0.375 x 0.058 Tube		
1	69830-07	Block	304 Stainless Steel, 0.25 Sqr. Rod		
1	69830-11	Guide	304 Stainless Steel, 0.75 x 0.065 Tube		
1	69830-21	Stop	6061-T6 Aluminum, 0.625 Rod		
1	69830-22	Knob	6061-T6 Aluminum, 0.75 Rod		
1	69830-23	Spring			
1	#10-32	C'Sunk Screw	Stainless		
1	MS21044C3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		JP
Powder Coat	Drawing 78630			gc
Final Inspection	Drawing 78630			gc.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 78631 Revision 0  
 Assembly: 78631-01 High Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Pair	78631-01	High Beam Assembly			
1	78631-02	Tube	304 Stainless Steel, 1x2x0.125 tube		
1	78630-03	Cap	321 Stainless Steel, 0.025 Sheet		
2	78630-04	Bushing	304 Stainless Steel, 0.375 x 0.058 Tube		
1	69830-07	Block	304 Stainless Steel, 0.25 Sqr. Rod		
1	69830-11	Guide	304 Stainless Steel, 0.75 x 0.065 Tube		
1	69830-21	Stop	6061-T6 Aluminum, 0.625 Rod		
1	69830-22	Knob	6061-T6 Aluminum, 0.75 Rod		
1	69830-23	Spring			
1	#10-32	C'Sunk Screw	Stainless		
1	MS21044C3	Nut			
	7029				

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		JP
Powder Coat	Drawing 78631			gc
Final Inspection	Drawing 78631			gc.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



LAKESHORE  
AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Clamp Assembly Part #: 78620-01  
Approval #: SH08-16 Serial #: --  
WO #: 2008-06 Quantity: 4  
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured  
Remarks: Including mounting hardware

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

April 11/08  
Date

Jff Clark  
Inspector's Signature

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Low Beam Assembly Part #: 78630-01  
Approval #: SH08-16 Serial #: --  
WO #: 2008-06 Quantity: 2  
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured  
Remarks: \_\_\_\_\_

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

April 11/08  
Date

Jff Clark  
Inspector's Signature

AIRSPAN

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

# AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Clamp Assembly Part #: 78620-01  
Approval #: SH08-16 Serial #: --  
WO #: 2008-06 Quantity: 4  
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured  
Remarks: Including mounting hardware

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

May 20/08  
Date

Jeff Clark  
Inspector's Signature

AIRSPAN

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

# AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: High Beam Assembly Part #: 78631-01  
Approval #: SH08-16 Serial #: --  
WO #: 2008-06 Quantity: 2  
Eligibility: Eurocopter AS350/355 Series Work Status: Manufactured  
Remarks: \_\_\_\_\_

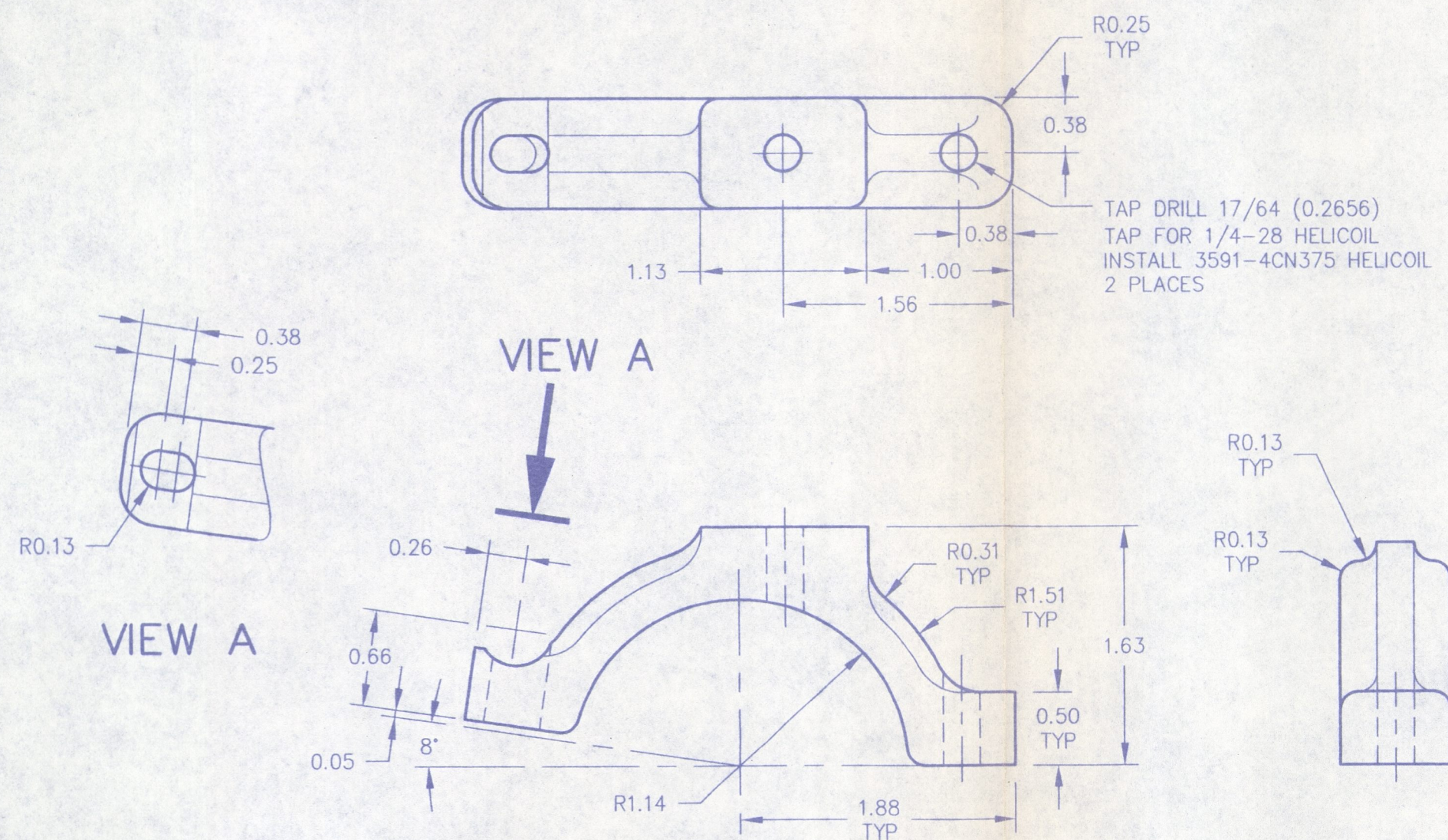
*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

May 20/08  
Date

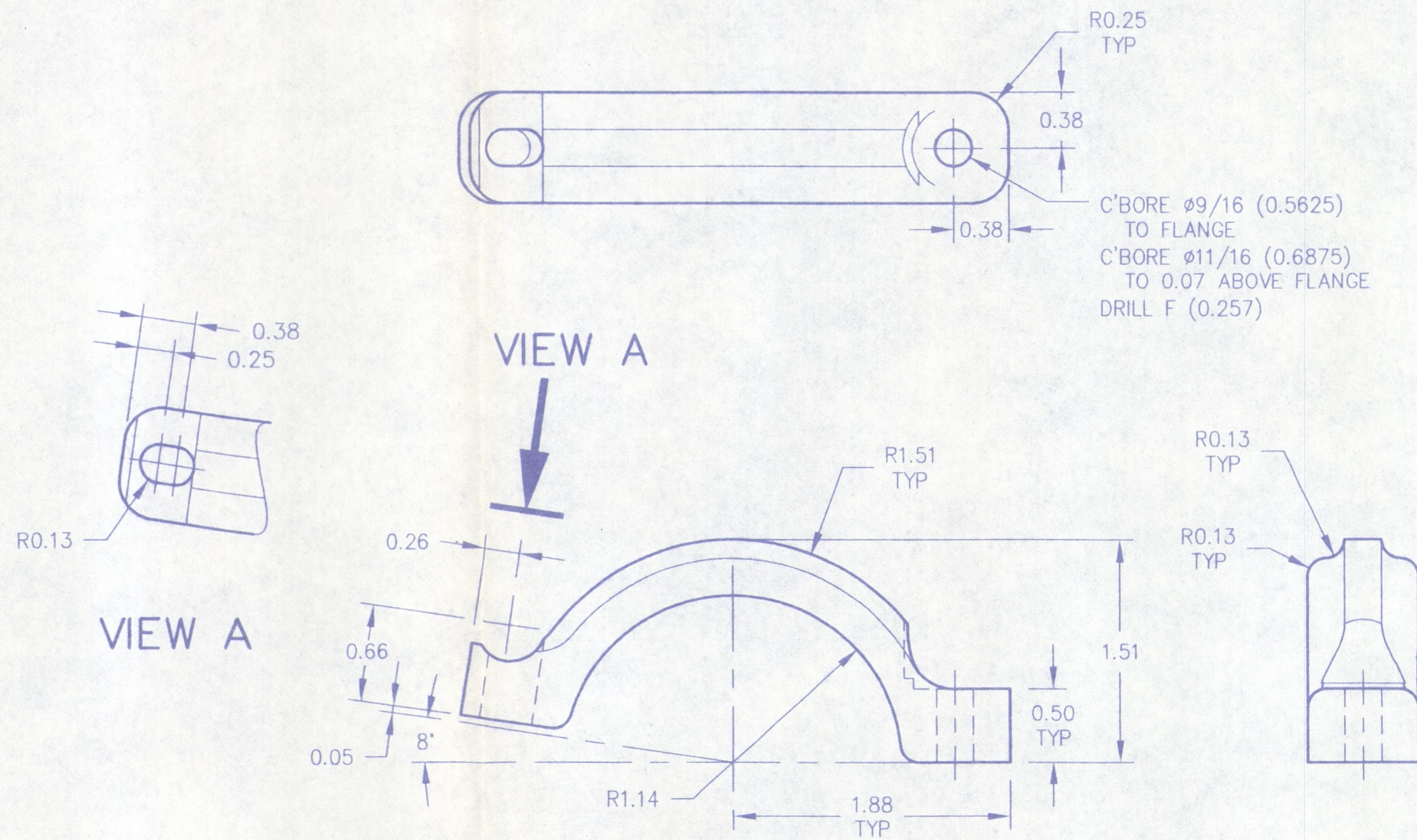
Jeff Clark  
Inspector's Signature



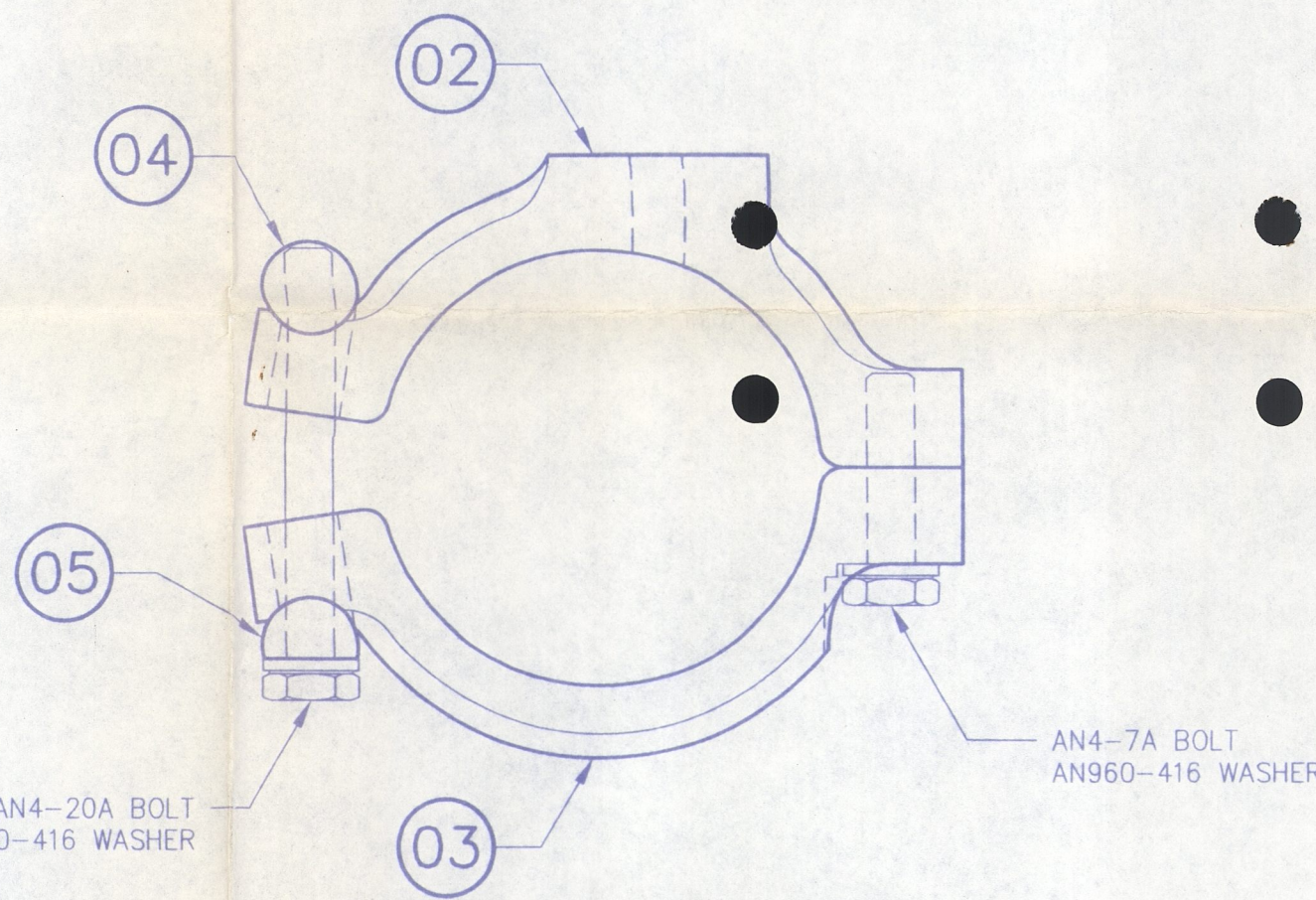
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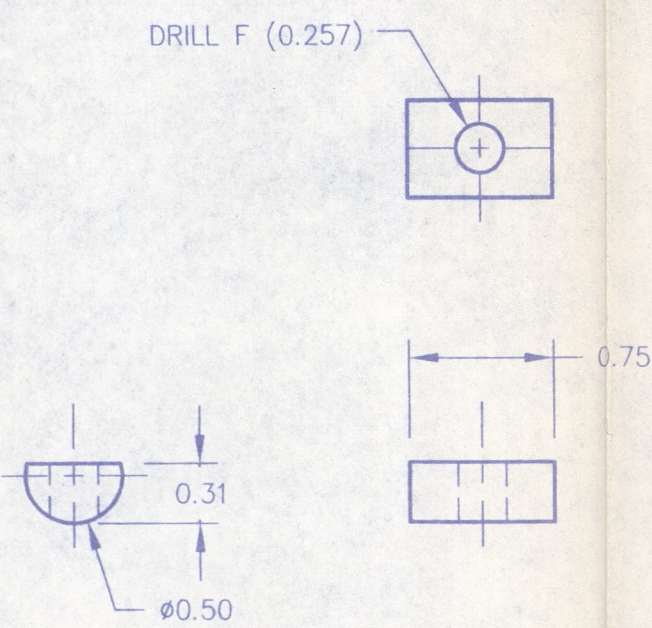
02 ATTACHMENT CLAMP  
SEE NOTE 2



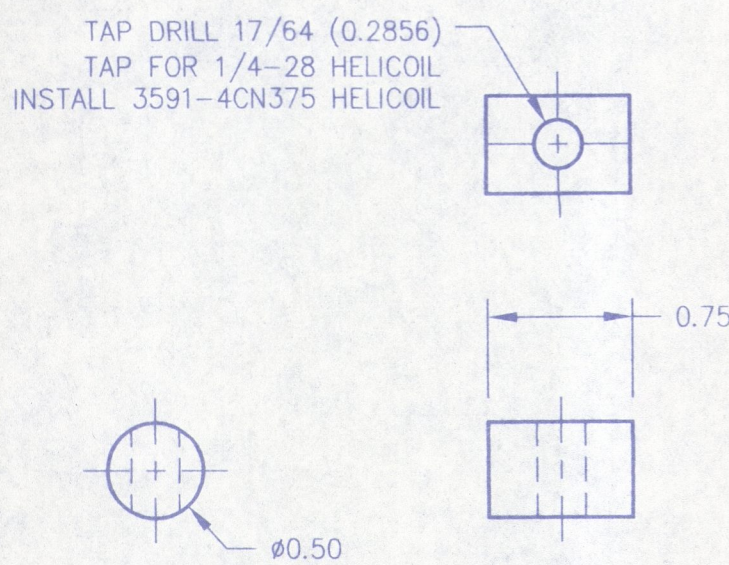
03 CLAMP  
SEE NOTE 2



01 CLAMP ASSEMBLY



05 CURVED WASHER



04 BARREL NUT

NOTES

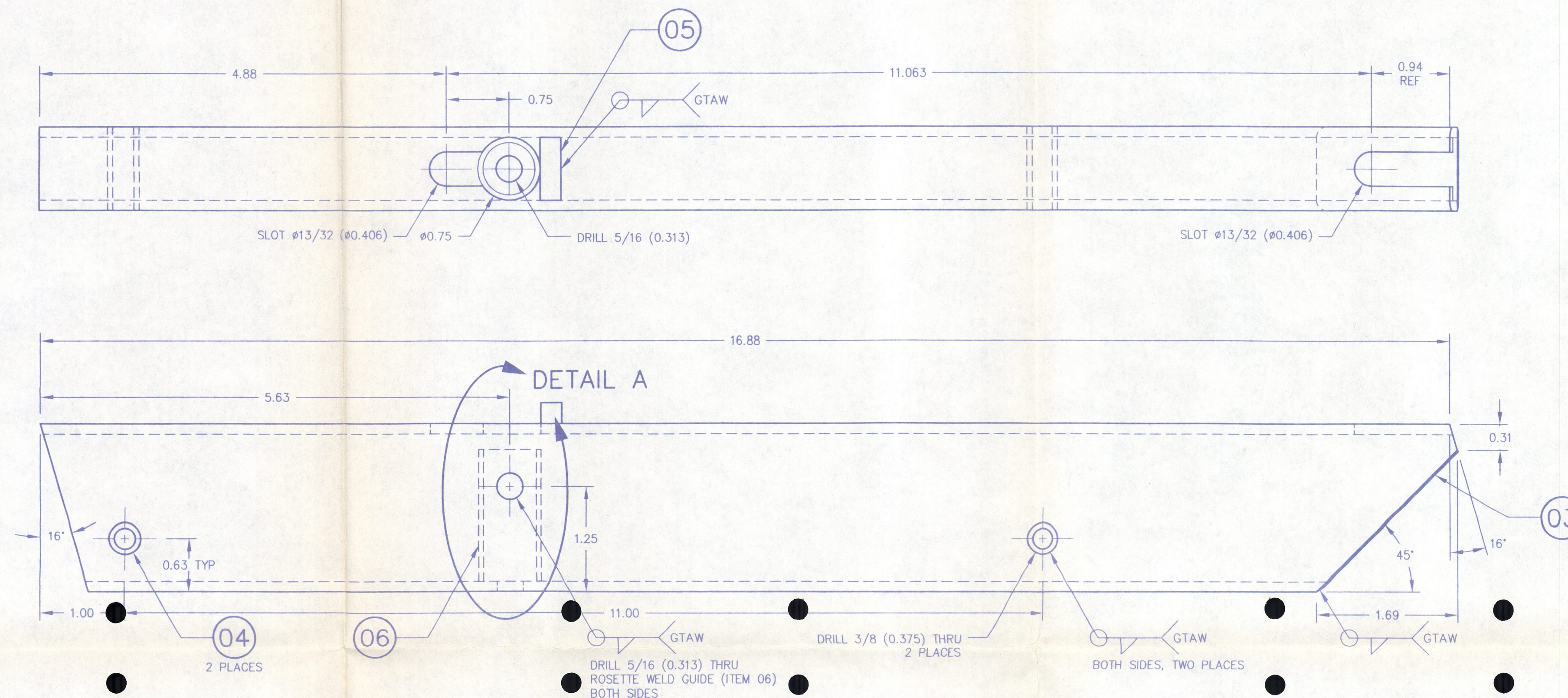
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- PARTS ARE CNC MACHINED AS A SET (ITEM 2/ITEM 3) FROM ONE PIECE OF MATERIAL.
- ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED, ALODINED, PRIMED AND PAINTED PRIOR TO ASSEMBLY.

QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		2	AN960-416		WASHER			
		1	AN4-20A		BOLT			
		1	AN4-7A		BOLT			
1	2		3591-4CN375		1/4-28 SELF LOCK HELICOIL		MS21209-F4-15	
		1	77620-05	05	CURVED WASHER	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.5 ROD
		1	77620-04	04	BARREL NUT	304 STAINLESS STEEL	MIL-S-5059	Ø0.5 ROD
		1	77620-03	03	CLAMP	6061-T6 ALUMINUM	QQ-A-200/8	3.5 X 1.0 BAR
		1	77620-02	02	ATTACHMENT CLAMP	6061-T6 ALUMINUM	QQ-A-200/8	3.5 X 1.0 BAR
		1	77620-01	01	CLAMP ASSEMBLY			

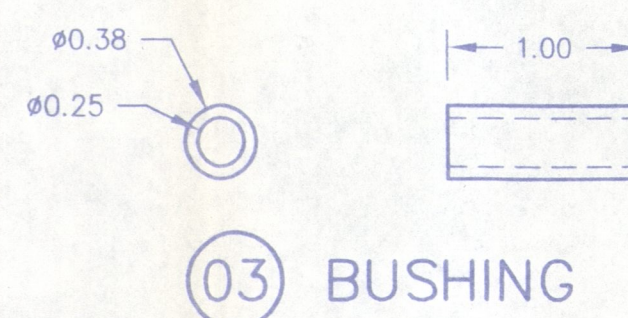
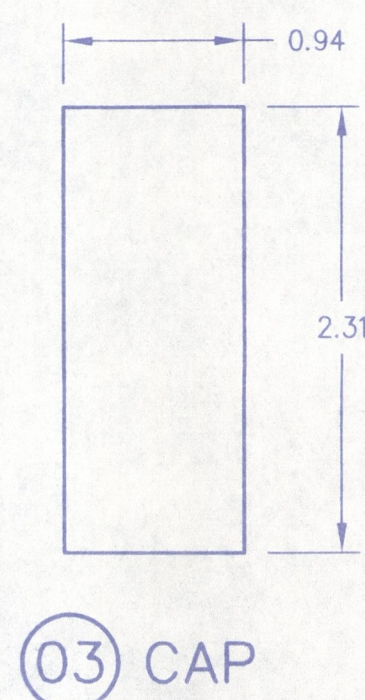
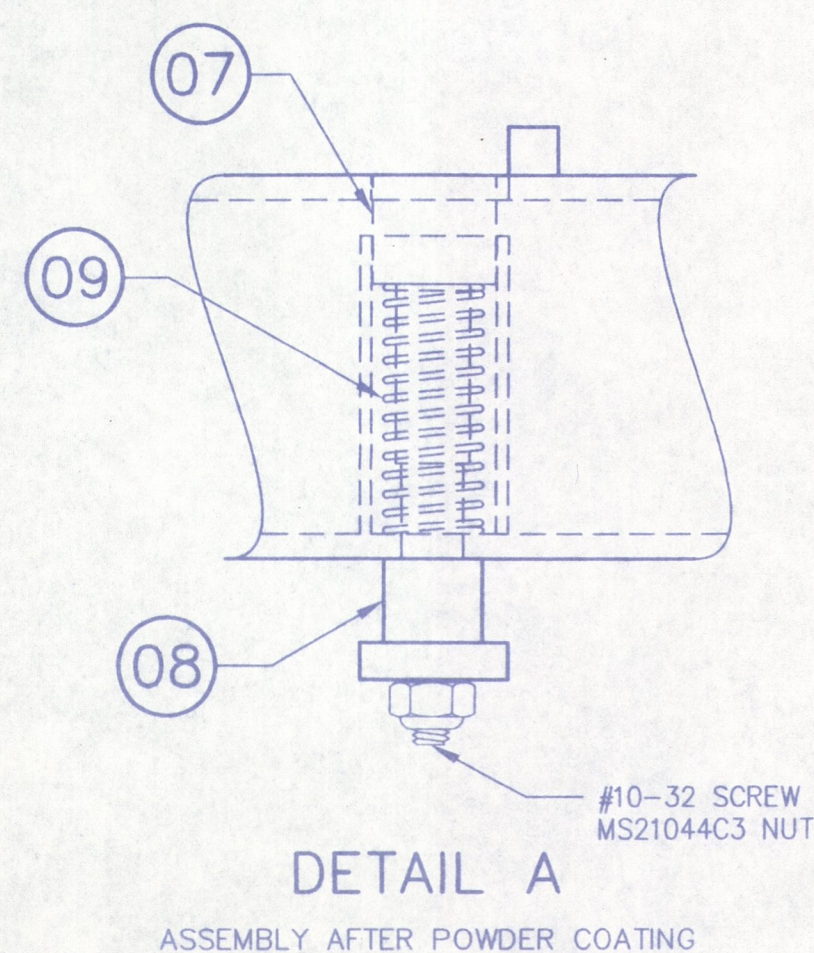
	APPROVALS		DATE		AERO DESIGN LTD.						
	DRAWN: JEFF CLARKE		29 NOV 2007		CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M						
	CHECKED: E. BURGOIN				2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7						
					tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca						
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				EUROCOPTER AS350 & AS355 SERIES EXTERNAL ATTACHMENT PROVISIONS CLAMPS FABRICATION						
	DECIMALS		ANGLES								
X.XXX ±0.010		±1/2°		SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
X.XX ±0.03				SHEET 1 OF 1		A1		78620		0	
X.X ±0.1											



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



01 LOW BEAM ASSEMBLY



NOTES

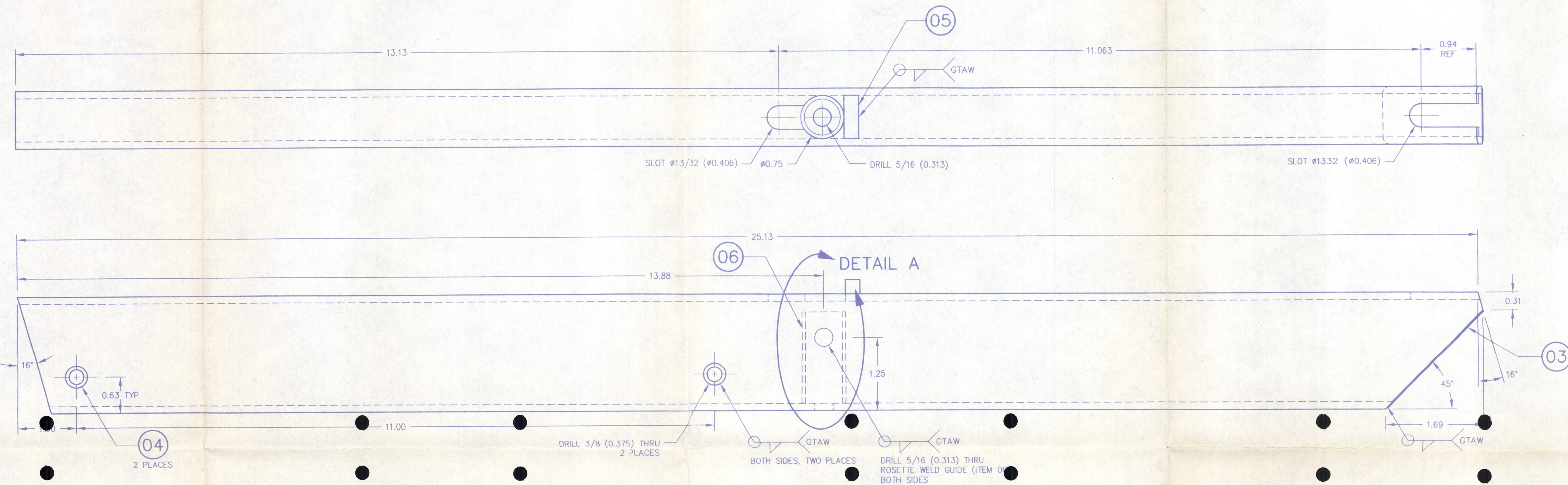
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	MS21044C3		NUT			
1	#10-32		C'SUNK SCREW	STAINLESS STEEL	COMMERCIAL	
1	69830-23	09	SPRING		COMMERCIAL	15mm X 70mm SPRING
1	69830-22	08	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.75 ROD
1	69830-21	07	STOP	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.625 ROD
1	69830-11	06	GUIDE	304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.065 RND. TUBE
1	69830-07	05	BLOCK	304 STAINLESS STEEL	ASTM A479	0.25 SQR ROD
2	77630-04	04	BUSHING	304 STAINLESS STEEL	ASTM A269	Ø0.375 X 0.058 RND. TUBE
1	77630-03	03	CAP	321 STAINLESS STEEL	AMS 5510	0.025 SHEET
1	77630-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	77630-01	01	LOW BEAM ASS'Y			

QTY		LIST OF MATERIALS																
		APPROVALS		DATE		<div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027      fax: (403) 250-8333      <a href="http://www.aerodesign.ca">www.aerodesign.ca</a></div>												
		DRAWN: JEFF CLARKE		6 DEC 2007														
		CHECKED: E. BURGOIN				<div>EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET LOW BEAM FABRICATION</div> <table><tr><td>SCALE 1 : 1</td><td>DWG. SIZE</td><td>DWG. NO.</td><td>REV.</td></tr><tr><td>SHEET 1 OF 1</td><td rowspan="2">A1</td><td rowspan="2">77630</td><td rowspan="2">0</td></tr><tr><td></td></tr></table>				SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	SHEET 1 OF 1	A1	77630	0	
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.															
SHEET 1 OF 1	A1	77630	0															
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		DECIMALS      ANGLES X.XXX    ±0.010      ±1/2" X.XX     ±0.03 X.X      ±0.1														

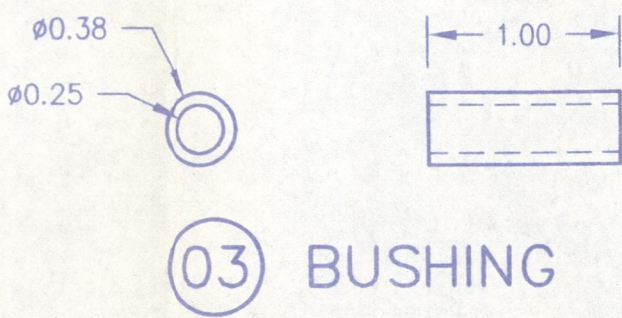
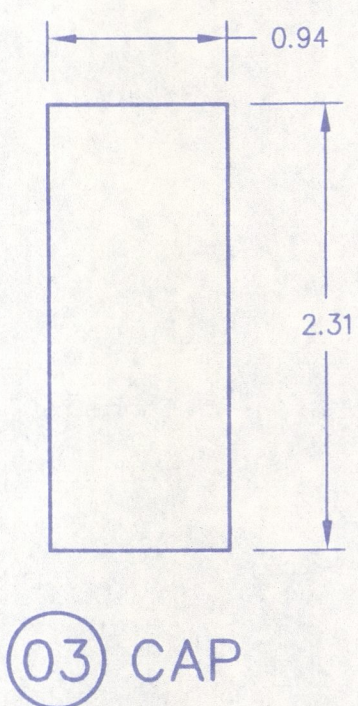
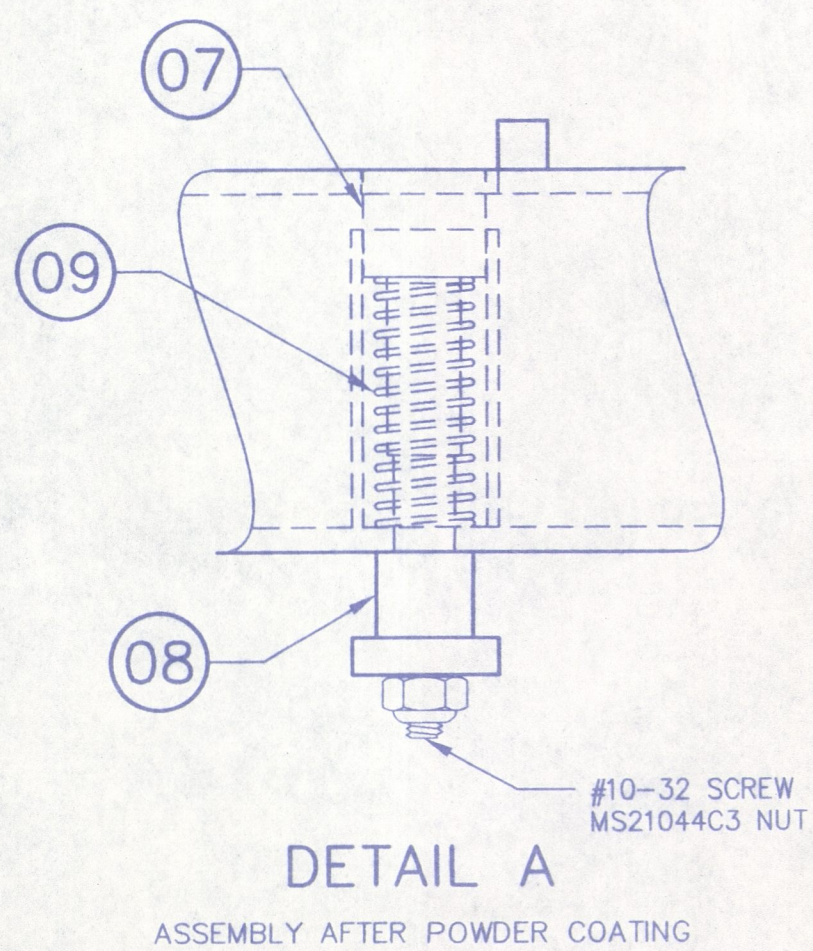


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



02 HIGH BEAM ASSEMBLY

- NOTES
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
  - WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
  - ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY.



QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	MS21044C3	NUT		STAINLESS STEEL	COMMERCIAL	
1	#10-32	C'SUNK SCREW		STAINLESS STEEL	COMMERCIAL	
1	69830-23	09	SPRING		COMMERCIAL	15mm X 70mm SPRING
1	69830-22	08	KNOB	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.75 ROD
1	69830-21	07	STOP	6061-T6 ALUMINUM	QQ-A-200/8	Ø0.625 ROD
1	69830-11	06	GUIDE	304 STAINLESS STEEL	ASTM A269	Ø0.75 X 0.065 RND. TUBE
1	69830-07	05	BLOCK	304 STAINLESS STEEL	ASTM A479	0.25 SQR ROD
2	77630-04	04	BUSHING	304 STAINLESS STEEL	ASTM A269	Ø0.375 X 0.058 RND. TUBE
1	77630-03	03	CAP	321 STAINLESS STEEL	AMS 5510	0.025 SHEET
1	77631-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
1	77631-01	01	HIGH BEAM ASS'Y			

QTY		LIST OF MATERIALS							
		APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca			
		DRAWN: JEFF CLARKE		6 DEC 2007					
		CHECKED: E. BURGOIN							
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 SERIES QUICK RELEASE CARGO BASKET HIGH BEAM FABRICATION			
		SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
		SHEET 1 OF 1		A1		77631		0	